

Work Order ID 153156

153156

Page 1

Tuesday, November 08, 2016 11:19:19 AM

Item ID: D4435-7 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket
 Start Date: 11/18/2016 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 11/23/2016 Req'd Qty: 2.00 ***2*** Customer:

Reference:

Approvals: Process Plan: DAS 21 Date: NOV 10 2016 Tooling: Date: Run Start ***NR1***
 QC: 9-89 Date: NOV 10 2016 SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr						DAS		
D4435	B						46		
							9-89		
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.03							
FLOW CNC Waterjet	1-Cut as per Dwg Dwg Rev: <u>B</u> Prog Rev: <u>B</u> 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00					DAS		
110							46		
QC	Memo	0.00					9-89		
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.01							
Quality Control									

DAS
38
9-89
NOV 18 2016

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Item ID: D4435-7

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Bracket

Start Date: 11/18/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 11/23/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

NR1

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Bend as per dwg

0.02

DAS
30
9-89

(2)

FEB 06 2017

130

Brake NC

Memo

0.05

DAS
36
9-89

Brake NC

C'sink as per dwg

150

QC5- Inspect part completeness to step on W/O

0.00

DAS
38
9-89***150***

QC

Memo

0.01

2

FEB 07 2017

Quality Control

160

Chemical Conversion Coat per QSI005 4.1

0.00

160

HandFinish

Memo

0.02

(x2)

✓

201202/07

BEB

Hand Finishing

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 *170* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo	0.00 0.00				2			DAS 38 2-80 F 07 2017
190 *190* Packaging Packaging	Identify as per dwg & Stock Location: <u>JK619</u> Memo	0.00 0.00				2			DAS 26 FEB 08 2017
200 *200* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.03							17/2/9 JF FEB 09 2017

Picklist Print

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Work Order ID: 153156

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Parent Item: D4435-7

D4435-7

Parent Item Name: Bracket

Start Date: 11/18/2016

Required Date: 11/23/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 11.10.05 NEW ISSUE DD VERF:EC
12.03.06 AS PER DWG REV.B DD VERF:EC

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.040		Purchased	No			100	sf	317.1300	0.77	1.621053			
M6061T6S 040									**		DAS 46 9-89	16/11/17	
6061-T6 .040 Sheet													

Location

Loc Qty

Loc Code

MAT021

317.13

m135147

1

m135612

39.61

m135632

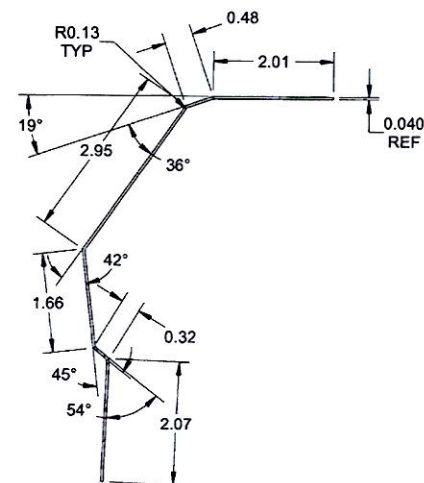
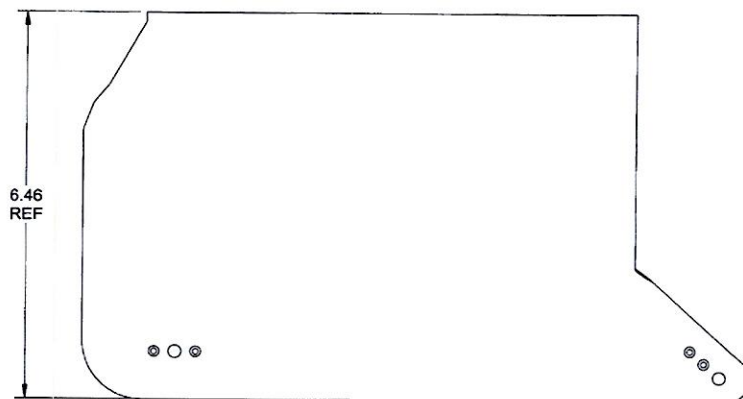
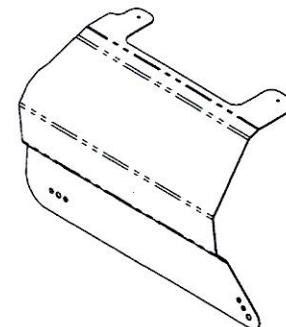
103.7

m135724

172.82

1.5

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 153156 MJS
18-11-10



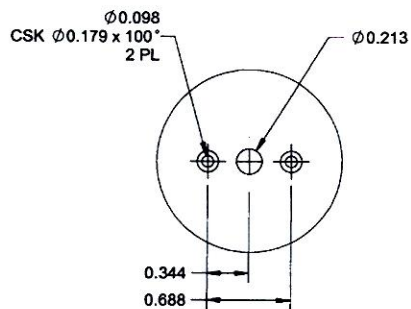
D4435-7 BRACKET

2012-03-02

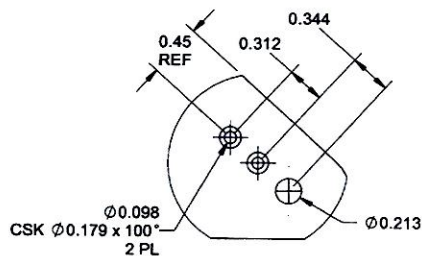
NOTES:

- 1) MATERIAL: MAKE FROM D4435-7F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.29 lbs

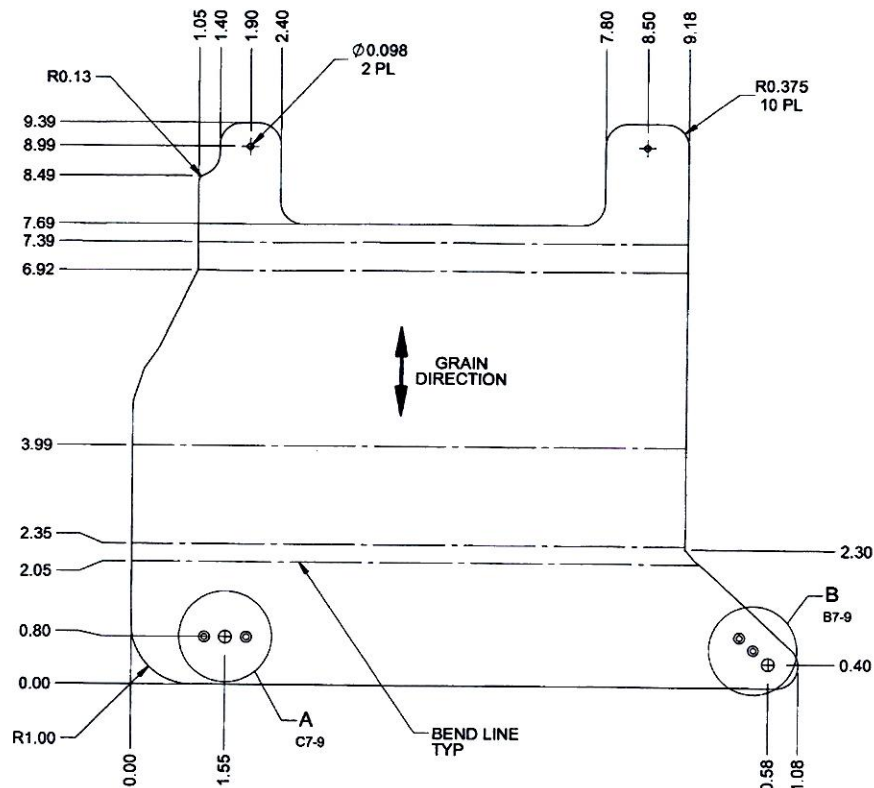
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4435	SHEET 8 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BRACKET	NTS
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DETAIL A
SCALE 2X B5-9



DETAIL B
SCALE 2X B3-9



D4435-7F FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC. M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.29 lbs

RELEASED
2012-03-02
JMY

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	140	DRAWING NO.	REV. B
MFG. APPR.	E	D4435	SHEET 9 OF 11
APPROVED	140	TITLE	SCALE
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